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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	19536
<b>Description:</b> Long Step Assembly - High Skid, RH		<b>Part Number:</b>	704A 41 640 007
D350-591-212			
<b>Dwg:</b> D3070 Rev. A1		<b>Qty:</b>	10
RF 02-11-13		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	SA	03.08.27	10
2	DC	Photocopy bluefile and type labels per PPP 704A 41 640 007 <del>CHG001</del> CHG002 WK 45	SA	04.03.12	10
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3070 using cutting table setup DT8185-2A <b>Pick:</b> Qty Part Number Description Batch 1 D2622-120C Extrusion B18809 <b>Ensure wall thickness is 0.070 to 0.090</b>	SB	04/03/03	10
4	GA	Drill extrusion per Dwg D3070 using Jig DT8680 for rivets.	SB	04/03/03	10
5	GA	Deburr	SA	04/03/03	10
6	QC5	Inspect work to Step 5	SA	04/03/03	10
7	WA	Bevel end for welding <b>FWD ONLY</b>	SA	04/03/03	10
8	WA	Weld Support using Jig DT8681, weld Fwd End Plate per QSI 004 & Dwg D3070 <b>Pick:</b> Qty Part Number Description Batch 1 D3063-1 Support B19555 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066	SA	04/03/03	10
9	GA	Grind End Plate flush	SB	04/03/04	10
10	QC9	Inspect weld and work to Step 9	SA	04/03/05	10
11	FP	Chemical conversion coat as per QSI 005 4.1	SA	04.03.08	10
12	GA	Assemble Leg Assembly as per Dwg D3070. D3066-1 are done with Step Leg Assy, don't add to the BOM. RF 03.01.13 <b>Pick:</b> Qty Part Number Description Batch 1 D3065-041 Step Leg Assy B19557 2 D3066-1 Spacer B19557 16 MS20600AD4W4 Rivet M13767	SA	04-03-15	10
13	QC5	Inspect work to step 12	SA	04/03/16	10
14	WA	Bevel Aft end for welding	SA	04/03/16	10
15	WA	Inspect for foreign object per QSI 024	SA	04/03/16	10
16	WA	Weld Aft End Plate per QSI 004 & Dwg D3070 <b>Pick:</b> Qty Part Number Description Batch 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066	SA	04/03/16	10

STEP 11 NCR 748 Complete 04.03.16.13  
Step 12  
POSITIVE RECALL

BB 04-03-25 AB

POSITIVE RECALL  
EFFECTIVE 04.03.15 AUTH [Signature]  
RELEASED [Signature] DATE 04.03.16 03.06.06 RF  
CANCELL FORM 16 UNDER REVIEW  
See Dwg

RELEASED  
02/11/01 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR # 748		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04-03-12	11	The Step was not HOMOGENE COLOUR "Poor Quality"	ml	Re do step 11	ml 04/03/12	SB 04/03/16	TH 04.03.16	04/05/16

PAR#: N/A Fault Category: N/A DQA: 11 Date: 04.03.29

NOTE: Date & initial all entries  
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QA: N/C Closed: N/A Date: N/A

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	19536
<b>Description:</b> Long Step Assembly – High Skid, RH D350-591-212		<b>Part Number:</b>	704A 41 640 007
<b>Dwg:</b> D3070 Rev. A 1		<b>Qty:</b>	10
		Page 2 of 2	

17	GA	Grind End Plate flush	SB	04/03/16	10																																																				
18	QC9 & 5	Inspect work to Step 17 – Check dimension 110.56" from Dwg D3070 110.71" RF 02.11.13	SP	04/03/16	10																																																				
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	L	04.03.22	10																																																				
20	FP	Wing Walk per Dwg D3070 and QSI 005 4.4 M14087	L	04.03.22	10																																																				
21	QC3	Inspect Powder Coat and Wing Walk	M	01.03.23	10																																																				
22	KP	<b>Pick: Packing Kit</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>D2182B035</td><td>Rubber Cushion</td><td>B20134</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B20207</td></tr><tr><td>2</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B19645</td></tr><tr><td>2</td><td>D3064-1</td><td>Clamp</td><td>B20123</td></tr><tr><td>1</td><td>D3079-041</td><td>Support Assy</td><td>B20456</td></tr><tr><td>4</td><td>D3080-1</td><td>Clamp</td><td>B19559</td></tr><tr><td>2</td><td>AN3-35A</td><td>Bolt</td><td>M13943/M12597</td></tr><tr><td>10</td><td>AN4-11A</td><td>Bolt</td><td>M13735/M12963</td></tr><tr><td>4</td><td>AN960JD10</td><td>Washer</td><td>M13441</td></tr><tr><td>20</td><td>AN960JD416</td><td>Washer</td><td>M13356/M13719</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M14019</td></tr><tr><td>10</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276/M12620</td></tr></table>	Qty	Part Number	Description	Batch	4	D2182B035	Rubber Cushion	B20134	8	D2274	Radius Block	B20207	2	D2856-400-720	Abrasion Strip	B19645	2	D3064-1	Clamp	B20123	1	D3079-041	Support Assy	B20456	4	D3080-1	Clamp	B19559	2	AN3-35A	Bolt	M13943/M12597	10	AN4-11A	Bolt	M13735/M12963	4	AN960JD10	Washer	M13441	20	AN960JD416	Washer	M13356/M13719	2	MS21042L3	Nut (or -3)	M14019	10	MS21042L4	Nut (or -4)	M13276/M12620	CP	04/03/04	10
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23	QC4	Inspect 100% Kit for Completeness on the W/O		04.03.25	10																																																				
24	PK	Package for shipping as per PPP 704A 41 640 007 Rev. A	CP	04/03/25	10																																																				
25	AC	Cost / part 239.30	54C	04.03.29	10																																																				
26	DC	Close W/O 239.30 Inspect Level 21	JA	04.03.29	10																																																				

Rev	Date	Change	Revised By	Approved
A	02.11.01	New issue	KJ RF	
A1	03.01.14	110.71" was 110.56" ; Dwg. Rev. A1	RF	
A2	03.07.16	D3194-041 was D3079-041 ; CHG002	RF	

UNDER REVIEW

03.06.06 RF

See David

CANCEL RF 03.01.16

RELEASED  
02/11/02

**Dart Aerospace Ltd**

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 27, 2003  
02:05 pm

Work Order No : 0019536  
Project Name : \*704A 41 640 007  
Project For : WK347  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*704A 41 640 007  
Description : Heli-Access-Step,Long RH  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 08-27-03  
Est Finish Date : 11-28-03  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

